

(19)



JAPANESE PATENT OFFICE

## PATENT ABSTRACTS OF JAPAN

(11) Publication number: **07060476 A**(43) Date of publication of application: **07.03.95**

(51) Int. Cl.

**B23K 33/00****B23K 9/00****B23K 9/028****B23K 9/035****// B23K101:06**(21) Application number: **05209781**(22) Date of filing: **24.08.93**(71) Applicant: **OMI TADAHIRO OSAKA  
OXYGEN IND LTD**(72) Inventor: **OMI TADAHIRO  
MIZUGUCHI YASUMITSU  
TANAKA TAKESHI  
MURAKAWA YORIYUKI**(54) **WELDED JOINTS AND WELDING METHOD**

## (57) Abstract

**PURPOSE:** To perform welding with the narrow bead width by providing a groove on inner walls of tubular ends.

**CONSTITUTION:** In the welded joints having the tubular ends to be welded, the groove is provided on the inner wall sides of the tubular ends. It is preferable that groove has an angle of 60-75° from the central axis and the depth from the tubular ends is regulated to 0.15-0.25mm. In addition, in the welding method of the welded joints having tubular parts, the groove is formed on the inner wall sides of the tubular ends of two welded joints, then, the welded joints are abutted on each other and welding

is performed along the periphery. It is preferable that the groove has the angle of 60-75° from the central axis and the depth from the tubular ends is regulated to 0.15-0.25mm.

COPYRIGHT: (C)1995,JPO